

Date: Wednesday, 6/6/2007 1:53:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 32789
 Estimate Number : 12711
 P.O. Number : N/A Part Number : D35373
 This Issue : 6/6/2007 S.O. No. : N/A Drawing Number : D3537 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : C
 Previous Run : 32071 Material : N/A
 Due Date : 6/22/2007 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : 07.06.07
 Comment : Est Rev:A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1512 sf(s)/Unit Total : 3.0240 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: M101873 (Hat remaining (125g)) SAD 07/06/11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary SAD 07/06/11 20

SAD 07/06/11

20 (PTO)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/11 20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07.06.12

20 counted

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3

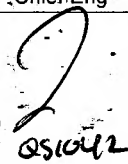
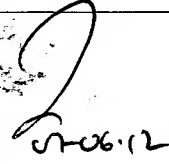
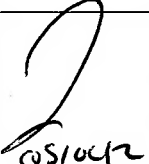
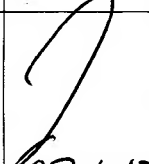

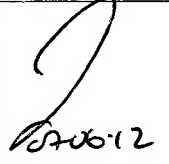

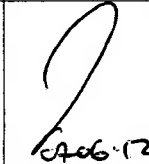
Form Joggle as per Dwg D3537 on brake using Jig DT8158

SB 07/06/22 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/11	2.0	One part scrap Because of machine malfunction. Machine cut in to material off of the side of the hole.	 QS1042	- Scrap / destroy / replace	SAD 07/06/11	 0706.12	 QS1042	 0706.12
07/06/11	2.0	One part scrap because of over all length was not correct, had to change offset. part too long by 0.015"	 QS1042	Acceptable	SAD 07/06/11	 0706.12	 QS1042	 0706.12

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 32789

Part Number: D35373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Counted
See 07/06/25 (20)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

U104463

See 07/06/27 (20)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

See 07/07/03 (20)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

See 07/07/03 (20)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 104846

BR / M-d / 07-07-03

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/07/03 (20)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *F-P 18*

M-d 07/07/03

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

See 07/07/03

Job Completion



See 07-07-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 32789
Description: Wearpad		Part Number: D3537-3
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

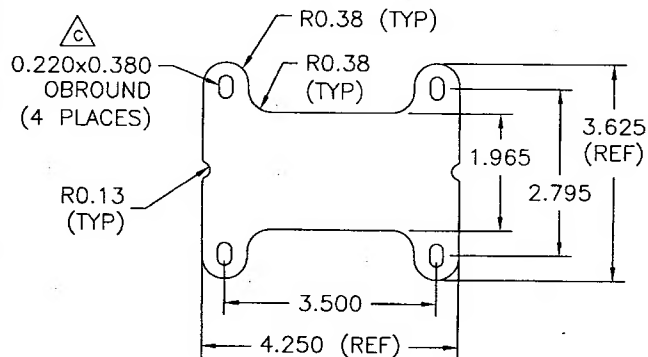
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.859	+/-0.010	5.866	/		Vern	
3.500	+/-0.010	3.505	/		Vern	
1.965	+/-0.010	1.971	✓		Vern	
2.795	+/-0.010	2.792	✓		Vern	
3.625	+/-0.010	3.619	✓		Vern	
0.220 x 0.380	+/-0.010	0.214 x 0.380	✓		Vern	

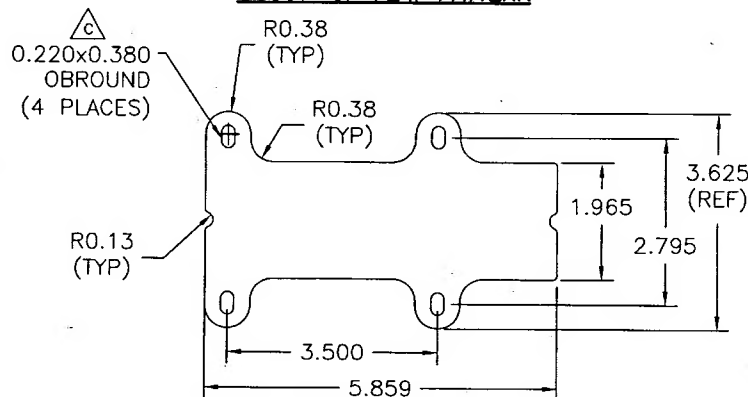
Measured by: SAD	Audited by: [Signature]	Prototype Approval: N/A
Date: 07/06/11	Date: 07-06-11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	

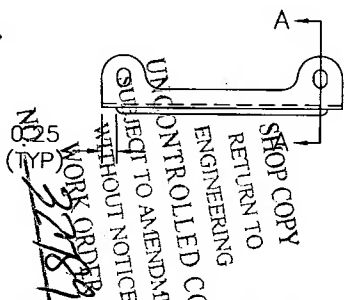
D3537-1F FLAT PATTERN



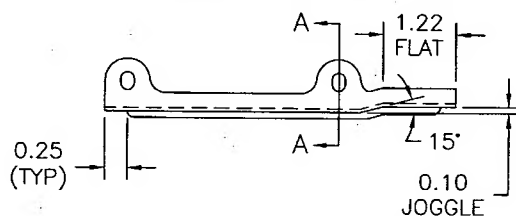
D3537-3F FLAT PATTERN



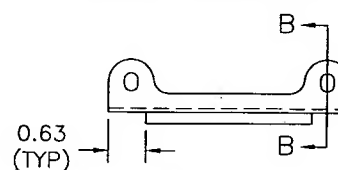
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



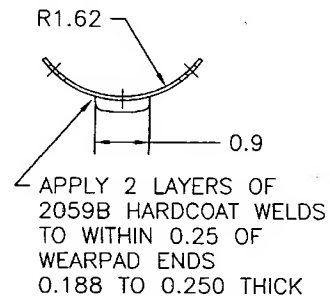
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



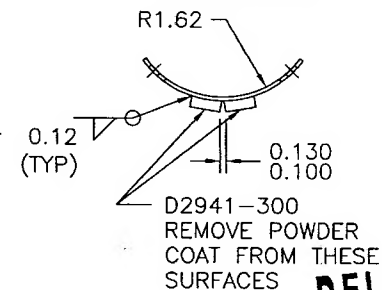
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



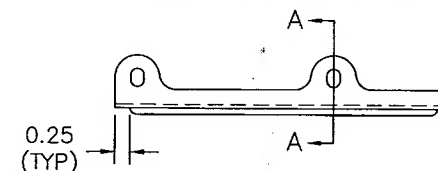
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08 PH
per ELCN
962